

Date: Friday, 9/15/2006 11:59:07 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASE PLATE PANEL
Job Number	: 28615		
Estimate Number	: 11213		
P.O. Number	: N/A	Part Number	: D33331
This Issue	: 9/15/2006 S.O. No. : N/A	Drawing Number	: D3333 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 10/5/2006 Qty: 10 Um: Each
Checked & Approved By	: <u>[Signature] 060915</u>		
Comment	: Est. C 05.04.15 Made in-house KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4140NB0750X04000	AISI 4140 Steel Bar
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Comment: Qty.: 0.7984 f(s)/Unit Total : 7.9842 f(s)
AISI 4140 Steel Bar
Material: AISI 4140 Steel Minimum yield tensile strength: 100ksi
(M4140N-B0.750x04.000)
Identify for D3333-1
Batch: M1022 77 [Signature] 06/10/16

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks: 9.00" x 4.00" x 0.750" thick [Signature] 06/10/16 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA478 and Dwg D3333
Identify as D3333-1 J.F. 06/10/21

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F. 06/10/21

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK J.G. 06/10/22 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DB Date: 06/11/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/08	6	Update estimate Holes need to be thread and mask before powder coat		Thread Holes	J.F 06/11/13			

NOTE: Date & initial all entries

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Drawing Name: BASE PLATE PANEL

Job Number: 28615

Part Number: D33331

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Deburr

J.F 06/10/22

10

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

YL 06/10/27 x 10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RS 06/10/31 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

WS

RS 06/10/31 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

RS 06/11/01

Job Completion



U 06-11-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

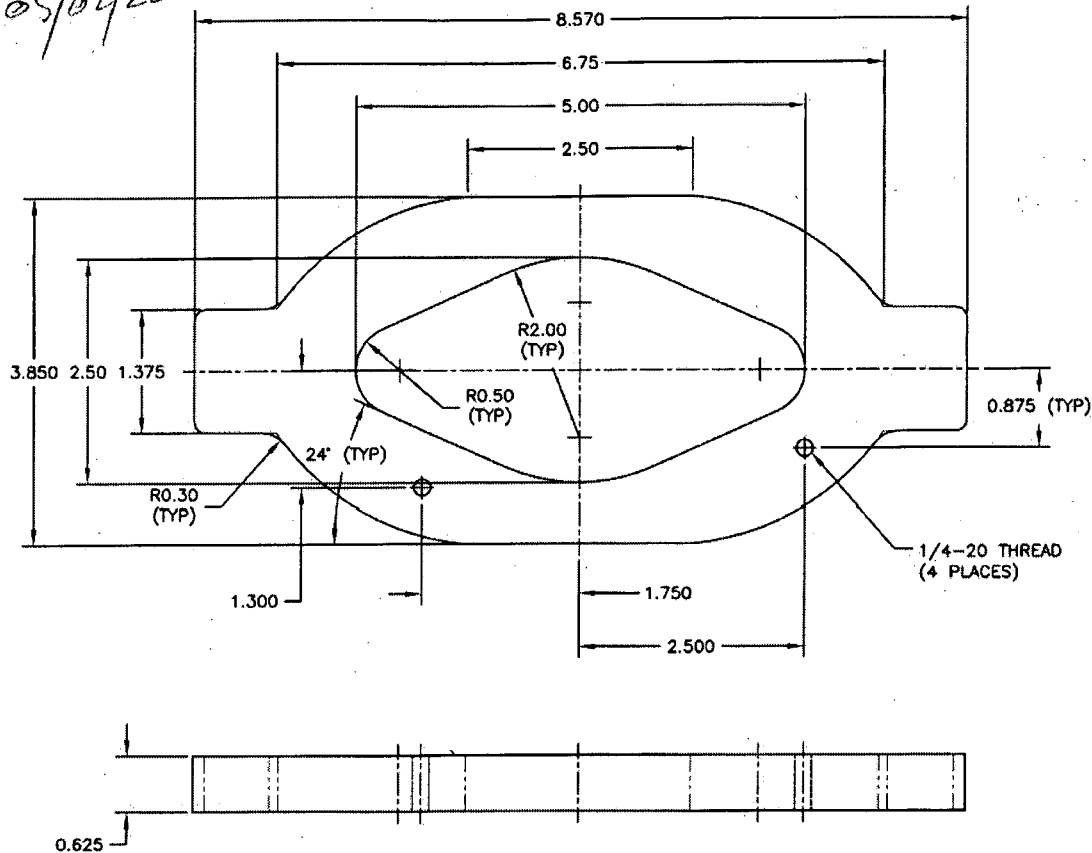
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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DATE 05.02.18		TITLE PLATE	SCALE 1:2
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

RELEASED
05/02/22



D3333-1 BASE PLATE PANEL

NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-4B) MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005.4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

NO. 28615

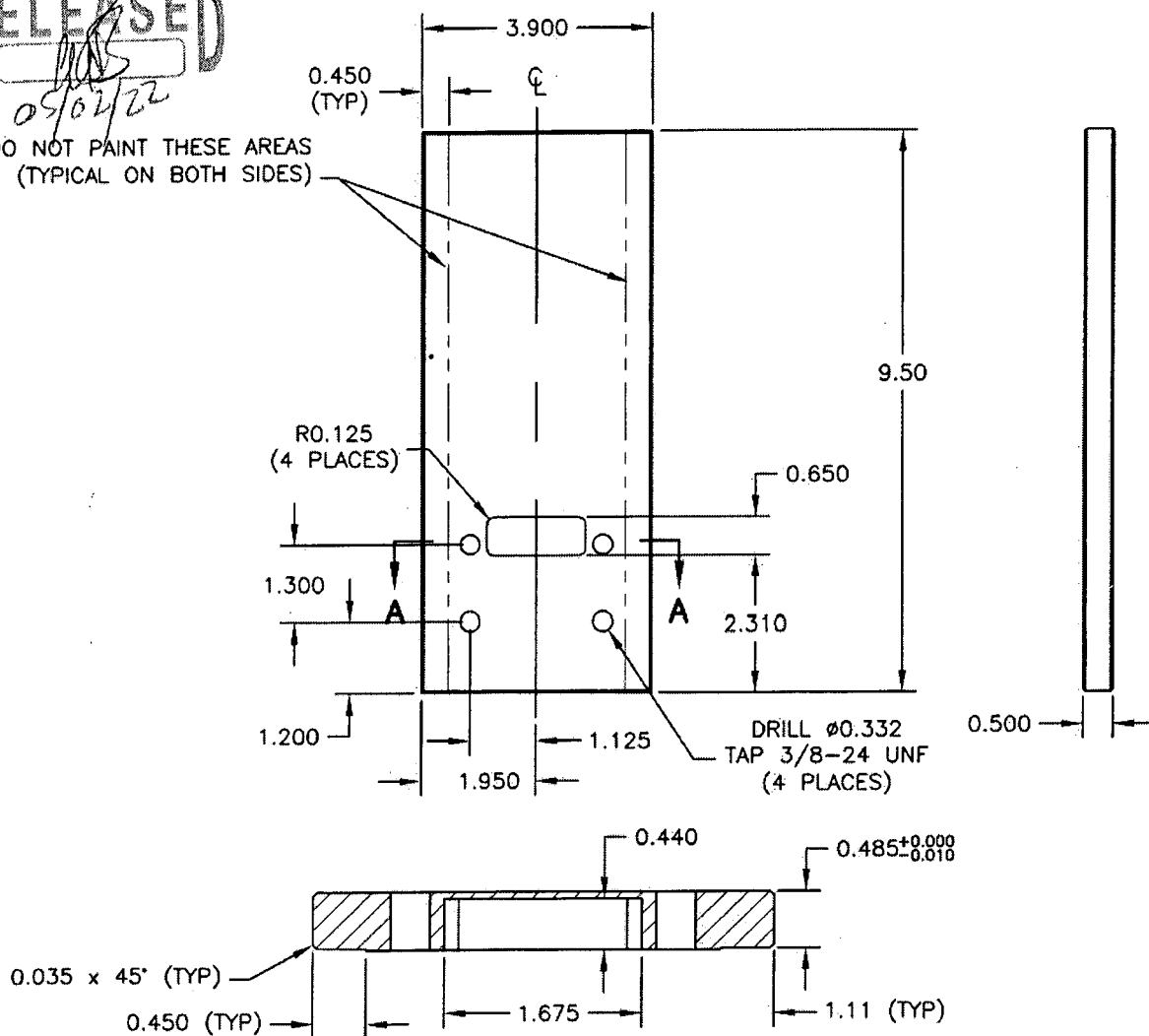
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DATE 05.02.18		TITLE PLATE	SCALE 1:4

RELEASED

DO NOT PAINT THESE AREAS
(TYPICAL ON BOTH SIDES)



SECTION A-A

D3333-3 SLIDING PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK
MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

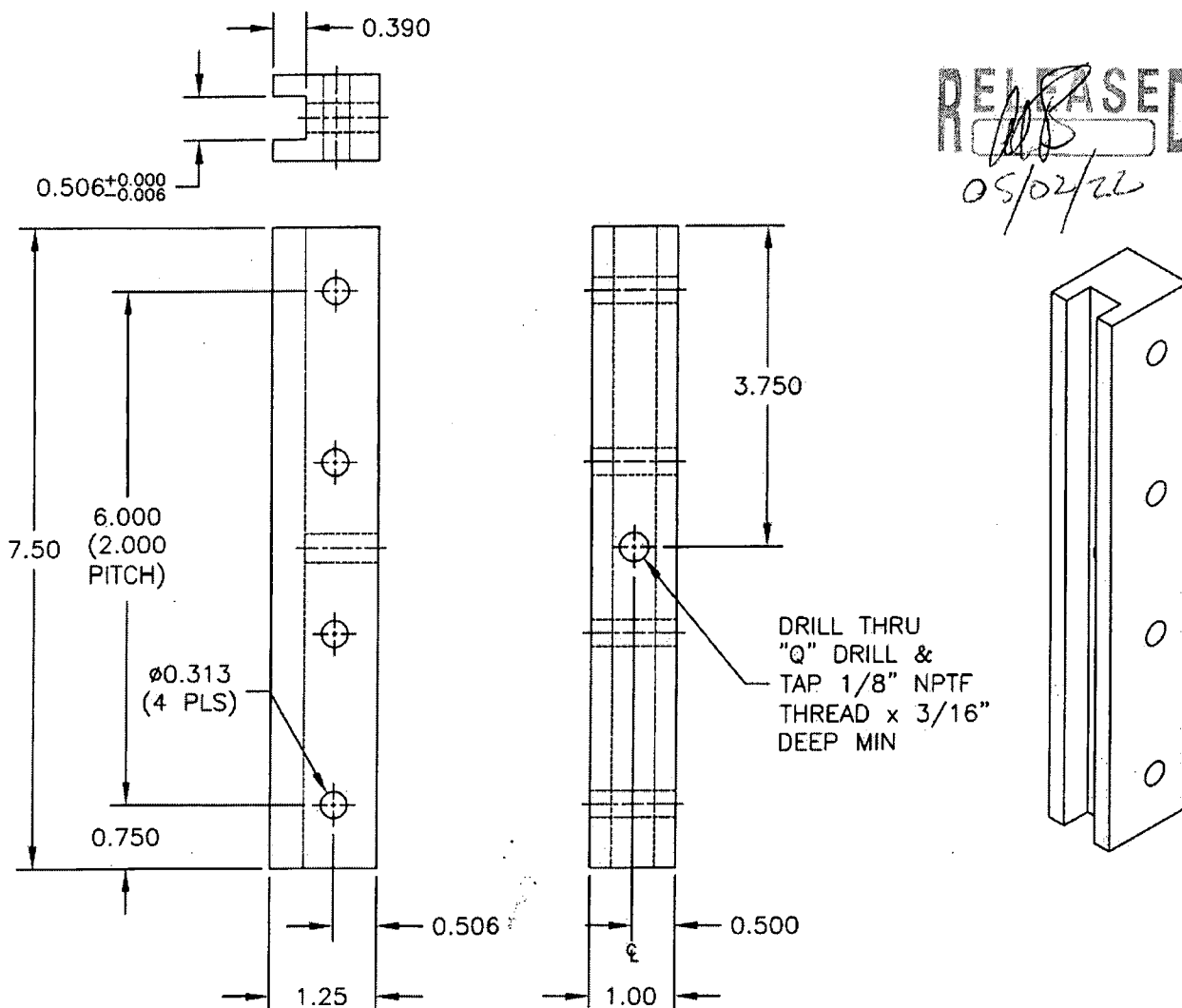
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DATE 05.02.18		TITLE PLATE	SCALE 1:2



RELEASED
05/02/22

D3333-5 RAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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